

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018121**Date Inspected:** 06-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 007252

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A6-009-001, 002, 007, 130
2. BK004A8-009-001, 002, 007, 165

Magnetic Particle Testing (MT) – NWIT Document No's: 007253

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK006A-002-002, 008, 017, 018, 019, 020, 021

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB021-096-031, 043, 055 and 067 located on Suspender Bracket. ZPMC Welder is identified as 062792. ABF Quality Control (QC) is identified as Mr. Peng Wen Jan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2233-Tc-U4b-F.

FCAW welding of weld joint SB021-096-006 and 077 located on Suspender Bracket. ZPMC Welder is identified as 062792. ABF Quality Control (QC) is identified as Mr. Peng Wen Jan. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint BK006A-002-13~21 located on bottom cover plate of OBG Bike path. ZPMC welder is identified as 259565. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G (1F) - Repair, which is used as per Critical Welding Repair Report (CWR) B-CWR-2117.

This QA inspector observed ABF and ZPMC personnel performed Magnetic Particle Testing on bottom cover plate of OBG Bike Path BK004A-002.

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint BK004A6-064-115, 116, 117 and 118 located on OBG Bike Path. ZPMC Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint BK004A8-064-043, 044, 117 and 118 located on OBG Bike Path. ZPMC Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2133.

FCAW welding of weld joint BK004A1-064-043 located on OBG Bike Path. ZPMC Welder is identified as 066912. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4c-F.

Visual Inspection after Blast

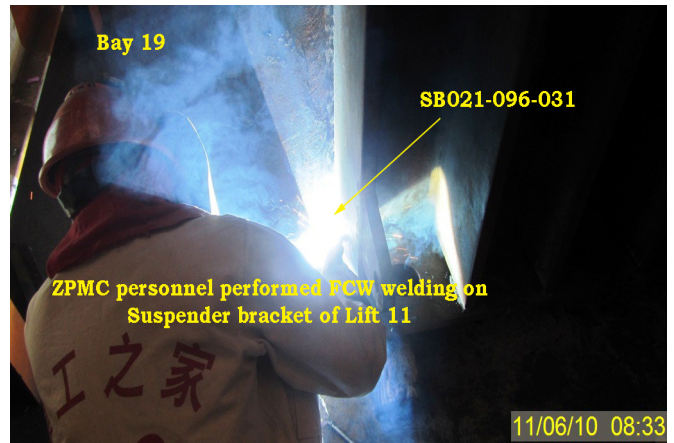
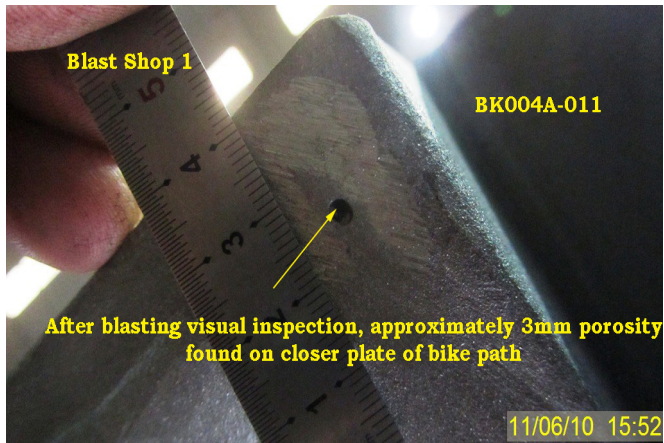
OBG Bike Path

This QA Inspector performed a preliminary random visual inspection on OBG Bike Path BK004A-002 and BK004A-011, after the grit blast of the exterior components of the deck plate, bottom cover plate and closer plate of these bike paths. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attaché picture.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer